

Quality Control

Work Order ID 116446

Wednesday, April 16, 2014 9:14:57 AM

116446

Page 2

Item ID: D2802-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm

Start Date: 4/17/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/18/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Deburr NO sharp edges.								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
N/A 4/14/23

14/04/22
DAS
44
9-89

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Item ID: D2802-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 4/17/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/18/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location WA003 0.00***160***

Packaging

Memo

0.00

Packaging

4X 14-4-23DAS
26
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14-4-2314-04-23

Picklist Print

Page 1

Wednesday, April 16, 2014 9:15:02 AM

Work Order ID: 116446

116446

Parent Item: D2802-2

D2802-2

Parent Item Name: Arm

Start Date: 4/17/14

Required Date: 4/18/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: B02.03.18Re-format NG
IPP: C06.02.13Removed p/cEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No			100	f	38.9125	1.5	2			

M6061T6B0 500X06 000

6061-T6 Bar .500 x 6.00

8.4945'

14-04-21

Location

Loc Qty

Loc Code

MAT005

38.9125

122521

7.747

m126647

15.2905

m128437

15.875

8.4945'

DART AEROSPACE LTD		Work Order:	116446
Description: Arm		Part Number:	D2802-2
Inspection Dwg: D2802 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.503	✓		MH-04	Caliper
Ø0.191	+0.005/-0.001	.191	✓			
1.500	+/-0.010	1.500	✓			
0.100	+/-0.010	.099	✓			
9.358	+/-0.010	9.359	✓		CNC-02	Caliper
Ø0.507	+0.000/-0.001	.5065	✓		Pin gauge	-
2.033	+/-0.010	2.033	✓		MH-04	Caliper
1.000	+/-0.010	1.002	✓			
2.000	+/-0.010	2.001	✓			
1.347	+/-0.010	1.348	✓			
R0.75	+/-0.030	.75	✓		rad gauge	-
R0.0300	+/-0.010	.03	✓		rad gauge	-
R0.125	+/-0.010	.125	✓		rad gauge	-
0.500	+/-0.010	.501	✓		MH-04	Caliper
0.125	+/-0.010	.126	✓			
Ø0.507 x 0.250	+0.000/-0.001 x +/-0.010	.5065 x .251	✓			
Ø0.375 x 100°	+/-0.010 x 0.5°	.375 x 100°	✓			
0.250	+/-0.010	.250	✓			
R0.032	+/-0.010	.032	✓		rad gauge	-

DAS

44
9-89

Measured by:	MH
Date:	14-04-22

Audited by:	
Date:	14/04/22

Prototype Approval:	N/A
Date:	N/A

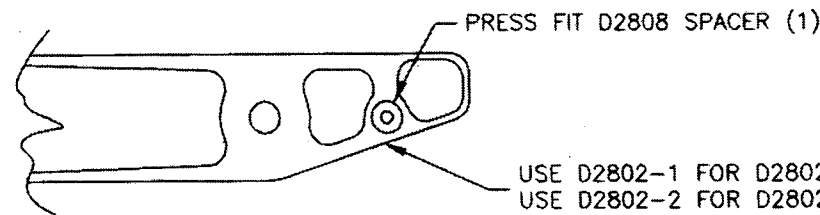
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	<i>[Signature]</i>

DART

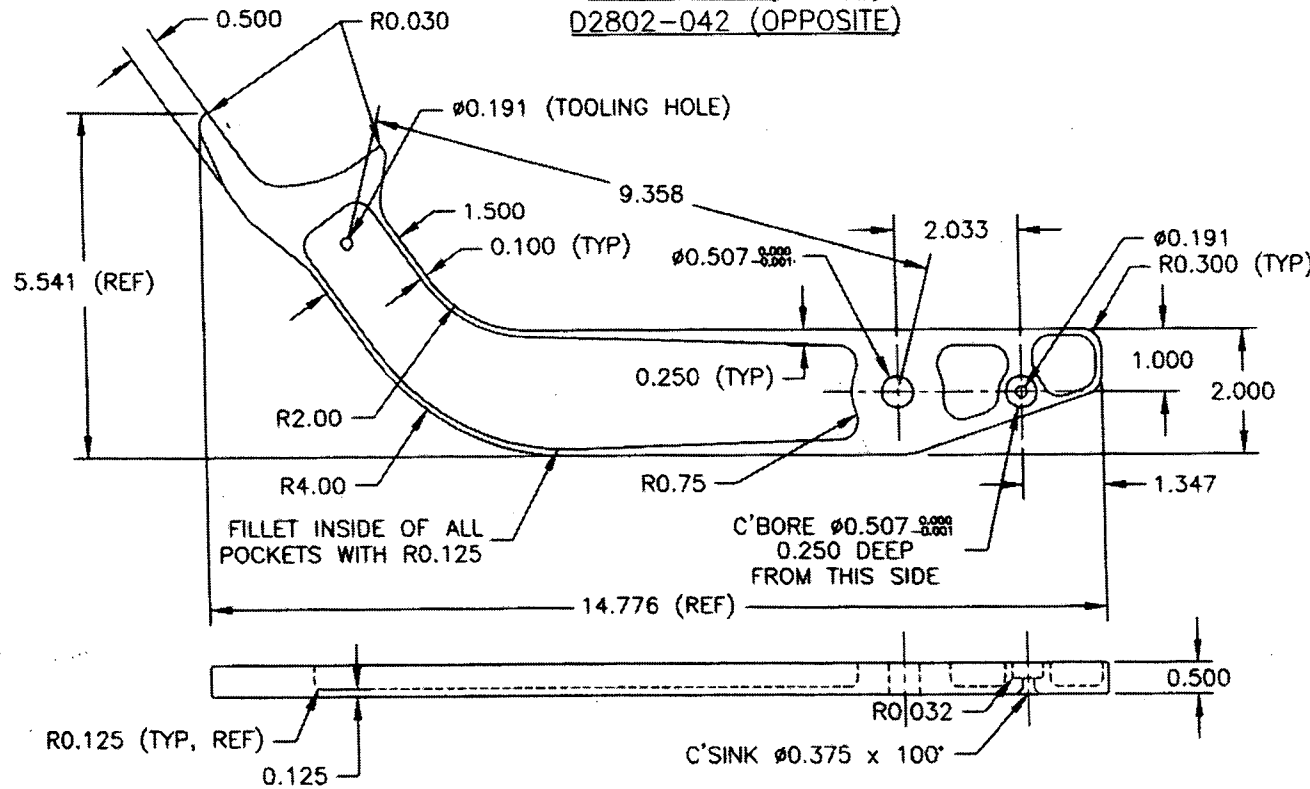


DESIGN	DRWN BY	DART Aerospace Ltd
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
00.11.03	ARM	SHEET 1 OF 1
A	00.11.03	SCALE
	NEW ISSUE	1:3

RELEASED
00-11-13



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED